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**D350-591-214**  
**Job Sheet 182135**



**Part No:** D350-591-214

**Job Qty:** 4 ea

**Part Name:** Heli-Access-Step™ RH - High Gear, Short Step, Aerazur Float Compatible



**Part Weight:** 0 lbs

**Status:** Scheduled

**Priority:** Medium

**Job Created:** 8/17/18

**Job Tracking No:**

**Due Date:** 9/7/18

**Created By:** Marie Lajeunesse

**Type:** Stock

**Description:**

**Note:** DWG REV H IPP Rev:B 05.10.14 Modified step 10 KJ/EC IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM IPP Rev:C 06-06-27 Revised as per DSI9340 JLM IPP Rev:D 10.11.15 update qty on AN4-11A DD verf:EC IPP REV:E 14.12.17 ADD DSI9712-011 DD VERF:JLM IPP REV:F 16.03.16 IIN REV.H DD VERF:JLM

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Lead Time | Sign-off    |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|-----------|-------------|
|       |                    |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |           |             |
| 90    | Start up Operation | 4 Ea  | 9/7/18     | 9/7/18   | 0.00      | 0.00    | Start Up Stores/Pkg-2 | DAS       | 6         | SEP 19 2018 |
| 270   | Packaging          | 4 pcs | 9/7/18     | 9/7/18   | 0.00      | 0.00    | Packaging1-3          | 6         | 9-85      | SEP 20 2018 |
| 280   | QC                 | 4 pcs | 9/7/18     | 9/7/18   | 0.00      | 0.00    | QC4                   | 9-89      | BB        | SEP 21 2018 |
| 290   | Packaging          | 4 pcs | 9/7/18     | 9/7/18   | 0.00      | 0.00    | Packaging3-1          | BB        | 5-85      | SEP 21 2018 |
| 295   | DC                 | 4 pcs | 9/7/18     | 9/7/18   | 0.00      | 0.00    | DC                    | EL        | 5-85      | SEP 21 2018 |
| 300   | QC21-FG            | 4 Ea  | 9/7/18     | 9/7/18   | 0.00      | 0.00    | QC21                  | 5-85      | 5-85      | SEP 21 2018 |

Part Op 290 - Identify and pack for shipping as per PPP D350-591-214 Location:FG039  
Descriptions: 295 - Photocopy bluefile and type labels as per PPP D350-591-214 CHG005

SEP 21 2018

### Job BOM

| Part / Item   | Component Name             | Quantity      | Operation             | Container    |
|---------------|----------------------------|---------------|-----------------------|--------------|
| AN3-35A       | Bolt                       | 8 Ea (2 ea)   | 90-Start up Operation |              |
| AN4-15A       | Bolt                       | 16 Ea (4 ea)  | 90-Start up Operation |              |
| AN5-36A       | Bolt                       | 8 Ea (2 ea)   | 90-Start up Operation |              |
| D2230-3       | Mounting Lug               | 8 Ea (2 ea)   | 90-Start up Operation |              |
| D2618         | Bushing                    | 8 Ea (2 ea)   | 90-Start up Operation |              |
| D2732-030     | Rubber Cushion - 3"        | 16 Ea (4 ea)  | 90-Start up Operation |              |
| D3235-1       | Mounting Lug               | 8 Ea (2 ea)   | 90-Start up Operation |              |
| D3338-1       | Mounting Lug               | 4 Ea (1 ea)   | 90-Start up Operation |              |
| MS21042L3     | Nut                        | 8 Ea (2 ea)   | 90-Start up Operation |              |
| MS21042L4     | Nut                        | 24 Ea (6 ea)  | 90-Start up Operation |              |
| MS21042L5     | Nut                        | 8 Ea (2 ea)   | 90-Start up Operation |              |
| NAS1149D0363J | Washer                     | 16 Ea (4 ea)  | 90-Start up Operation |              |
| NAS1149D0463J | Washer                     | 48 Ea (12 ea) | 90-Start up Operation |              |
| NAS1149D0563J | Washer                     | 16 Ea (4 ea)  | 90-Start up Operation |              |
| D3078-042     | Step Assembly, Hi Short RH | 4 Ea (1 ea)   | 270-Packaging         | 5093723<br>5 |

Container No: S111855

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Part: D350-591-214

Job No: 182135

Serial No/Batch: S111855

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH92-6 Issue 11, FAA-TC SH967NE 04/12/21, BRAZIL 1

| Job Allocations                    |                |          |           |           |
|------------------------------------|----------------|----------|-----------|-----------|
| Operation                          | Component Part | Required | Inventory | Allocated |
| 90-Start up Operation              | AN3-35A        | 8        | 403       | 0         |
|                                    | AN4-15A        | 16       | 685       | 0         |
|                                    | AN5-36A        | 8        | 346       | 0         |
|                                    | D2230-3        | 8        | 219       | 0         |
|                                    | D2618          | 8        | 195       | 0         |
|                                    | D2732-030      | 16       | 300       | 0         |
|                                    | D3235-1        | 8        | 0         | 0         |
|                                    | D3338-1        | 4        | 66        | 0         |
|                                    | MS21042L3      | 8        | 3,288     | 0         |
|                                    | MS21042L4      | 24       | 4,086     | 0         |
|                                    | MS21042L5      | 8        | 864       | 0         |
|                                    | NAS1149D0363J  | 16       | 2,245     | 0         |
|                                    | NAS1149D0463J  | 48       | 7,192     | 0         |
|                                    | NAS1149D0563J  | 16       | 1,636     | 0         |
| 270-Packaging                      | D3078-042      | 4        | 5         | 0         |
| Part Specifications                |                |          |           |           |
| Specifications could not be found. |                |          |           |           |

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## Container View (Active) - Master Unit Containers

| Master Unit No | Container No | Part No       | Part Name           | From Container | Current Location | Quantity |
|----------------|--------------|---------------|---------------------|----------------|------------------|----------|
| 005548         | S047337      | AN3-35A       | Bolt                | 5089307        | ST348            | 1        |
| 005548         | S111681      | AN3-35A       | Bolt                | S089307        | ST348            | 7        |
| 005548         | S111680      | AN4-15A       | Bolt                | S083012        | ST343            | 16       |
| 005548         | S111679      | AN5-36A       | Bolt                | S083019        | ST336            | 8        |
| 005548         | S111678      | D2230-3       | Mounting Lug        | S106786        | ST521            | 8        |
| 005548         | S111677      | D2618         | Bushing             | S089996        | ST008            | 8        |
| 005548         | S111676      | D2732-030     | Rubber Cushion - 3" | S108181        | ST410            | 16       |
| 005548         | S111392      | D3235-1       | Mounting Lug        | S110872        | ST522            | 8        |
| 005548         | S111683      | D3338-1       | Mounting Lug        | S026722        | ST527            | 4        |
| 005548         | S111675      | MS21042L3     | Nut                 | S089340        | ST303            | 8        |
| 005548         | S111674      | MS21042L4     | Nut                 | S094597        | ST303            | 24       |
| 005548         | S111673      | MS21042L5     | Nut                 | S083541        | ST303            | 8        |
| 005548         | S111672      | NAS1149D0363J | Washer              | S068661        | ST263            | 16       |
| 005548         | S111671      | NAS1149D0463J | Washer              | S089299        | ST263            | 48       |
| 005548         | S111670      | NAS1149D0563J | Washer              | S093773        | ST263            | 16       |

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

D3078-042

S107963x4

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| Qty<br>-213 | Qty<br>-214 | Qty<br>-215 | Qty<br>-216 | Qty<br>-311 | Qty<br>-312 | Part Number   | Description                                   |
|-------------|-------------|-------------|-------------|-------------|-------------|---------------|-----------------------------------------------|
| X           |             |             |             |             |             | D350-591-213  | Heli-Access-Step™, Short Step – High Skid, LH |
|             | X           |             |             |             |             | D350-591-214  | Heli-Access-Step™, Short Step – High Skid, RH |
|             |             | X           |             |             |             | D350-591-215  | Heli-Access-Step™, Short Step – Low Skid, LH  |
|             |             |             | X           |             |             | D350-591-216  | Heli-Access-Step™, Short Step – Low Skid, RH  |
|             |             |             |             | X           |             | D350-591-311  | Heli-Access-Step™, Long Step – High Skid, LH  |
|             |             |             |             |             | X           | D350-591-312  | Heli-Access-Step™, Long Step – High Skid, RH  |
| 1           |             |             |             |             |             | D3078-041     | STEP ASSEMBLY (HIGH-SHORT, LH)                |
|             | 1           |             |             |             |             | D3078-042     | STEP ASSEMBLY (HIGH-SHORT, RH)                |
|             |             | 1           |             |             |             | D3168-041     | STEP ASSEMBLY (LOW-SHORT, LH)                 |
|             |             |             | 1           |             |             | D3168-042     | STEP ASSEMBLY (LOW-SHORT, RH)                 |
|             |             |             |             | 1           |             | D3272-041     | STEP ASSEMBLY (HIGH-LONG, LH)                 |
|             |             |             |             |             | 1           | D3272-042     | STEP ASSEMBLY (HIGH-LONG, RH)                 |
| 2           | 2           | 2           | 2           | 4           | 4           | D2230-3       | MOUNTING LUG                                  |
| 2           | 2           | 2           | 2           | 2           | 2           | D2618         | BUSHING                                       |
| 4           | 4           | 4           | 4           |             |             | D2732-030     | CUSHION                                       |
|             |             |             |             | 2           | 2           | D2856-400-720 | ABRASION STRIP                                |
| 2           | 2           | 2           | 2           | 2           | 2           | D3235-1       | MOUNTING LUG                                  |
|             |             |             |             | 1           | 1           | D3278-041     | SUPPORT ASSEMBLY                              |
| 2           | 2           | 2           | 2           | 2           | 2           | AN3-35A       | BOLT                                          |
|             |             |             |             | 8           | 8           | AN4-13A       | BOLT                                          |
| 4           | 4           | 4           | 4           |             |             | AN4-15A       | BOLT                                          |
| 2           | 2           | 2           | 2           | 2           | 2           | AN5-36A       | BOLT                                          |
| 4           | 4           | 4           | 4           | 4           | 4           | NAS1149D0363J | WASHER (AN960JD10)                            |
| 12          | 12          | 12          | 12          | 16          | 16          | NAS1149D0463J | WASHER (AN960JD416)                           |
| 4           | 4           | 4           | 4           | 4           | 4           | NAS1149D0563J | WASHER (AN960JD516)                           |
| 2           | 2           | 2           | 2           | 2           | 2           | MS21042L3     | NUT                                           |
| 6           | 6           | 6           | 6           | 8           | 8           | MS21042L4     | NUT                                           |
| 2           | 2           | 2           | 2           | 2           | 2           | MS21042L5     | NUT                                           |
|             |             |             |             | 1           | 1           | *DSI 9410-011 | STEP MODIFICATION KIT                         |

\*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.

REFERENCE ONLY

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G AND  
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-591 REV. 3

REF TCCA STC: SH92-6

REF FAA STC: SH967NE

## 1.0 Purpose

It has come to DART's attention that it may be difficult to fasten the D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Step Installations to the forward crosstube due to variations between crosstubes. For this reason, DART is adding the D3338-1 Mounting Lug to the D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Step Kits at CHG 004 and later.

For D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Step Kits at CHG 003 and earlier, DSI 9712-011 Mounting Lug Kit can be procured from DART. The kit contains all parts to upgrade a single step kit.

## 2.0 Installation

- 2.1 It is acceptable to install the D3338-1 Mounting Lug in lieu of the D2230-1 Mounting Lug as required to reduce the gap between step and the forward crosstube in accordance with the figures of this service instruction.
- 2.2 The height to set up the D350-591-133 Maintenance Step has been revised from 7.0in to 6.0in  $\pm$  1.0in to provide more flexibility. See sheet 2 of this service instruction.
- 2.3 In all other respects, install the D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Steps in accordance with Section 3.1 of Installation Instructions D350-591 or Section 32.1 of Instructions for Continued Airworthiness ICA-D350-591.

## 3.0 Parts List Change

The following additional part is provided with D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Steps at CHG 004:

| Qty<br>-133 | Qty<br>-213 | Qty<br>-214 | Part Number  | Description                                   |
|-------------|-------------|-------------|--------------|-----------------------------------------------|
| X           |             |             | D350-591-133 | Heli-Access-Step™, Aft Maintenance Step       |
|             | X           |             | D350-591-213 | Heli-Access-Step™, Short Step – High Skid, LH |
|             |             | X           | D350-591-214 | Heli-Access-Step™, Short Step – High Skid, RH |
| 1           | 1           | 1           | D3338-1      | MOUNTING LUG (ADD)                            |

## 4.0 DSI 9712-011 Mounting Lug Kit Parts List

For existing D350-591-133 Aft Maintenance Steps and D350-591-213/-214 Heli-Access-Steps at CHG 003 or earlier, one DSI 9712-011 kit upgrades one step installation:

| Qty<br>-011 | Part Number  | Description      |
|-------------|--------------|------------------|
| X           | DSI 9712-011 | Mounting Lug Kit |
| 1           | D3338-1      | MOUNTING LUG     |

REFERENCE ONLY

## 5.0 Weight and Balance

There is a negligible weight change associated with this modification.

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY:   
D. SHEPHERD (DE # 02)

DATE: 14.12.04  
CERT. NO.: SH92-6  
ISSUE NO.: 11

|            |                                                                                     |                                                                                                                                                                                                                                                                          |              |
|------------|-------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| A          | NEW ISSUE                                                                           | MB                                                                                                                                                                                                                                                                       | 14.10.22     |
| REV.       | DESCRIPTION                                                                         | BY                                                                                                                                                                                                                                                                       | DATE         |
| DESIGN     |  | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                        |              |
| DRAWN      |  |                                                                                                                                                                                                                                                                          |              |
| CHECKED    |  | DRAWING NO.                                                                                                                                                                                                                                                              | REV. A       |
| MFG. APPR. | N/A                                                                                 | DSI 9712                                                                                                                                                                                                                                                                 | SHEET 1 OF 3 |
| APPROVED   |  | TITLE                                                                                                                                                                                                                                                                    | SCALE        |
| DE APPR.   |  | INSTALLATION OPTION                                                                                                                                                                                                                                                      | NTS          |
| DATE       | 14.10.22                                                                            | COPYRIGHT © 2014 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. |              |



## Change Record

PAGE 1 OF 1

**Part Number:** D350-591-213/-213GB/-214/-214GB

**Description:** HELI-ACCESS STEP, HIGH SKID, SHORT STEP, LH/RH

[illegible]